



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C10-C **Job Sheet 192173**



Part No: C10-C

Job Qty: 1 pcs

Part Name: Single Cage



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/18/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C10-C REV 2 IPP Rev. A 19.03.18 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	External Load - 2 - B4B	1 pcs	4/12/19	4/12/19	0.00	1.00	External Load - 1		AR 2019/05/13 MICHEL
							External Load - 2		
							External Load - 3		
120	QC 5	1 pcs	4/12/19	4/12/19	0.00	0.00	QC 5 - 10		SR 19/05/13
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
140	Packaging 3-1 - Stock - B4B	1 pcs	4/12/19	4/12/19	0.00	0.00	Packaging 3 - 1 - B4B		SR 19/05/13
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S180637



Part: C10-C

Job No: 192173

Serial No/Batch: S180637

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 05/13/19

				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	1 pcs	4/12/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - ASSEMBLE AS PER DWG ***HAND TIGHTEN ALL BOLTS, SPREAD COTTER PIN JUST ENOUGH SO THAT IT
 Descriptions: WILL NOT FALL OUT***

120 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg & Stock Location: _____)

160 - (QC21- Final Inspection - Work Order Release)

Job BOM

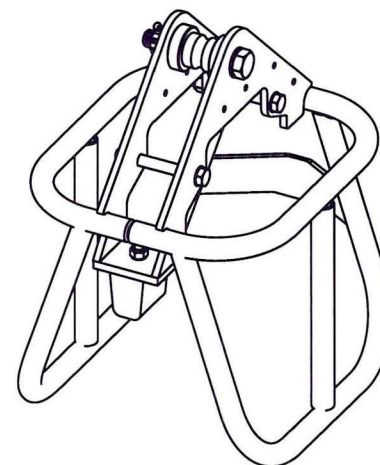
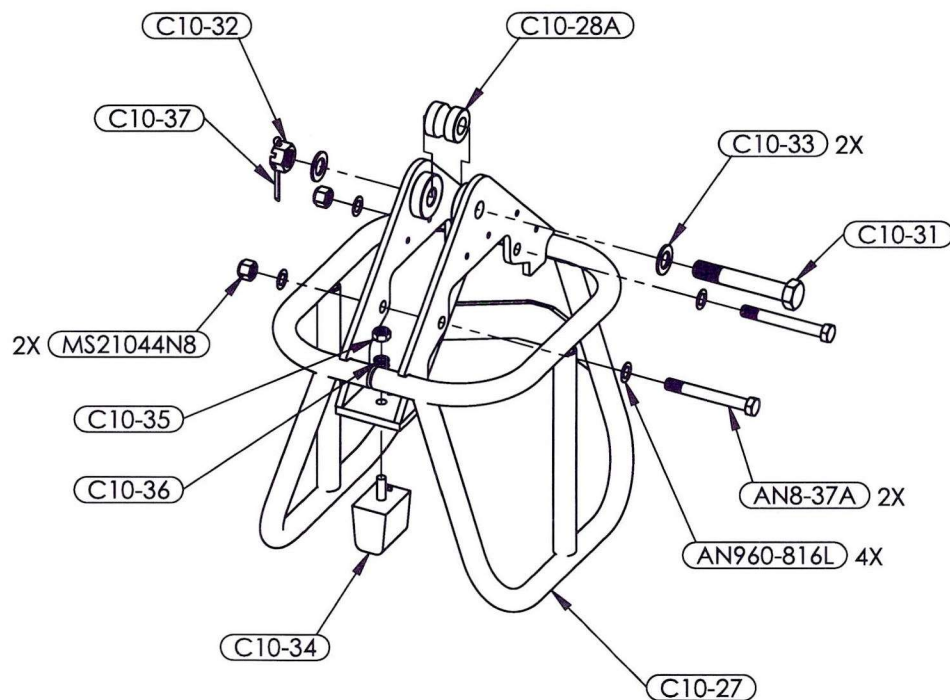
Part / Item	Component Name	Quantity	Operation	Container
AN12H40	Bolt	1 pcs (1 ea)	100-External Load - 2 - B4B	5099982
AN310-12	Castellated Nut	1 pcs (1 ea)	100-External Load - 2 - B4B	5004853
AN8-37A	1/2-20 X 3.969" Bolt	2 Ea (2 ea)	100-External Load - 2 - B4B	5127355
C10-27	Cage Weldment	1 pcs (1 ea)	100-External Load - 2 - B4B	5172915
C10-28A	Lifting Bushing (No Swivel)	1 pcs (1 ea)	100-External Load - 2 - B4B	5005644
C10-34	Bumper	1 pcs (1 ea)	100-External Load - 2 - B4B	5098664
G10-35 MS	Cage Bumper Nut 50576A118	1 pcs (1 ea)	100-External Load - 2 - B4B	5075954 S 142212
C10-37	Cotter Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	5075954 S 142212
MS21044N8	Nut, Self-Lock .500-20, UNJF-3B	2 Ea (2 ea)	100-External Load - 2 - B4B	5147505
NAS1149C0663R	Washer	1 Ea (1 ea)	100-External Load - 2 - B4B	5076016-1
NAS1149F0832P	Washer	4 Ea (4 ea)	100-External Load - 2 - B4B	5076018
NAS1149F1232P	Washer	2 Ea (2 ea)	100-External Load - 2 - B4B	5068664
MS24665-363	COTTER PIN	1		5092509-1

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-External Load - 2 - B4B	AN12H40	1	14	0
	AN310-12	1	33	0
	AN8-37A	2	32	0
	C10-27	1	0	0
	C10-28A	1	0	0
	C10-34	1	7	0
	C10-35	1	47	0
	C10-37	1	0	0
	MS21044N8	2	60	0
	NAS1149C0663R	1	526	0
	NAS1149F0832P	4	255	0
	NAS1149F1232P	2	82	0
Part Specifications				
Specifications could not be found.				

Plex 3/18/19 3:07 PM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0260	UPDATED TO NEW DRAFTING STANDARDS. C10-29 REPLACED W/ AN8-37A. C10-30 REPLACED W/ AN960-816L. C10-38 REPLACED W/ MS21044N8.	9/10/2015	DPD	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

192173 M-5
19-03-18

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C10-27	1	CAGE WELDMENT		
			C10-28A	1	LIFTING BUSHING	4140/4142	
			C10-31	1	LIFTING BOLT	STEEL	3/4-10 X 5-1/2, GRADE 8 (MCMaster-CARR #91257A857) MODIFIED
		B/O	C10-32	1	LIFTING BOLT NUT	STEEL	3/4-10 (MCMaster-CARR #97190A035)
		B/O	C10-33	2	LIFTING BOLT WASHER	STEEL	3/4 (MCMaster-CARR #98017A220)
			C10-34	1	BUMPER	RUBBER	E3TZ-4730-A (MODIFIED)
		B/O	C10-35	1	CAGE BUMPER NUT	STEEL	M10 x 1.5 (MCMaster-CARR #90576A118)
		B/O	C10-36	1	CAGE BUMPER WASHER	STEEL	(MCMaster-CARR #91074A131)
		B/O	C10-37	1	COTTER PIN	STEEL	Ø3/16 X 3 (MCMaster-CARR #98338A290)
		B/O	AN8-37A	2	CAGE BOLT	STEEL	1/2-20 X 3.969
		B/O	AN960-816L	4	WASHER	STEEL	Ø1/2
		B/O	MS21044N8	2	LOCK NUT	STEEL	1/2-20

DART AEROSPACE	
TITLE C10 CAGE	
DWG NO. C10-C	
REV 2	
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/8 ANGLES ± 5° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: APICAL APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL
SCALE 1:8	DATE 11/28/2011 SHEET 1 OF 1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					